

Tuesday, 29/04/2008 11:05:32 AM
Melanie Fauteux

Process Sheet

OK

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: TUBE	
Job Number	: 38887				
Estimate Number	: 10804				
P.O. Number	:		Part Number	: D37695	
This Issue	: 29/04/2008	S.O. No. :	Drawing Number	: PROTOTYPE	
Prsh Rev.	: NC		Project Number	:	
First Issue	: / /		Drawing Revision	: A 08.04.23	
Previous Run	: 38880		Material	:	
Written By	:		Due Date	: 16/05/2008 Qty: 2 Um: Each	
Checked & Approved By	:				
Comment	:				

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1		
MAKE PER DRWG D3769 REV A		
2.0	M6061T6T1000W065	6061T6 TUBE
Comment: Qty.: 1.7577 f(s)/Unit Total : 3.5154 f(s)		
6061T6 TUBE		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
ENGINEERING APPROVAL		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1		
ACID ETCH AND ALODINE PER QSI 005		
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHMICAL CONVERSION		

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: TUBE

Job Number: 38887

Part Number: D37695

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

GIVE TO CHRIS P-ENG

FOR ENGINEERING USE ONLY

PJ
08.05.29

CHARGE TO JOB #00196

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.05.29 Prototype

Job Completion



U 080611

8

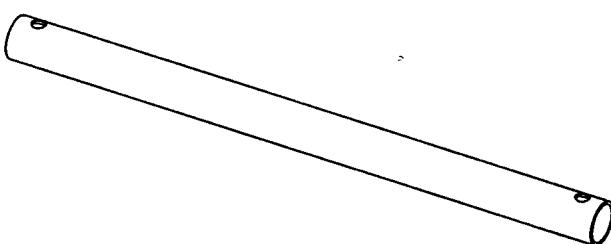
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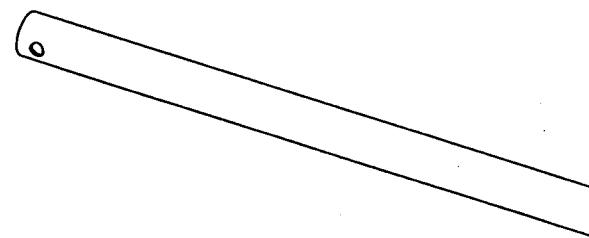
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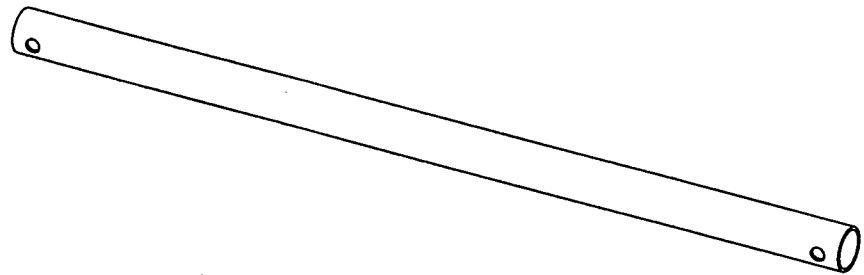
D3769-1 TUBE



D3769-3 TUBE

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM TUBING 1.00" X 0.065" WALL (REF. DART SPEC. M6061T6T1.00C)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3769-1, 0.27 lbs
D3769-3, 0.28 lbs
D3769-5, 0.37 lbs



TUBE

D3769-5 TUBE

PROTOTYPE

PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

9/68.64.23

M6061T6T1.000W.065)

REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A	SHEET 1 OF 4
DRAWN	HS			
CHECKED		DRAWING NO.		
MFG. APPR.		D3769		
APPROVED		TITLE		SCALE
DE APPR.		TUBE		NTS
DATE	08.03.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

Receiving Report

Date: 8/6/08Supplier: MARMUR
 Packing Slip: Yes No
 Invoice: Yes No
 Receipt: Cash Cr
Batch No: M107950Dart P/O: 6269
 Release Note Attached: Yes No N/A
 Waybill Attached: Yes No
 Shipment Complete: Yes No N/A
 QC6 Inspection: OK N/A
 Work Order: OK N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 CL

Production/Admin:

Date 08/05/08Received/Costing R/R 7822Initial CL

Location _____

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

RECEIVED MAY 09 2008

Energy Surcharge

12.20

ORIGINAL INVOICE / FACTURE ORIGINALE

 CREDIT: NET 30 DAYS
 PLUS 2% PER MONTH ON
 OVERDUE ACCOUNTS.

 TERMES: NET 30 JOURS
 PLUS 2% PAR MOIS
 SUR COMPTE PASSE DÜ.

 FOR CONDITIONS OF SALE REFER TO BACK OF INVOICE.
 POUR LES CONDITIONS DE VENTE, VOUS TROUVEZ LES
 RENSEIGNEMENTS À L'ENDOS DE LA FACTURE ORIGINALE.

G.S.T. /HST	18.02
PROVINCIAL TAX TAXE PROVINCIALE	.00

06/04/2008

378.38

 PAYMENT OF THIS INVOICE IS DUE BY
 LE RÉGLEMENT DE CETTE FACTURE EST EXIGIBLE AU PLUS TARD LE

FEB 18 2008 15:44 FR MARMON KEYSTONE

6309722464 TO 14506414357

P.02/03

02/18/2008 From: MARMON/KEYSTONE
 M/K OR:
 C.P.O.:
 C PART:

INIT.:

TO:

 OR. REF:
 SLSPRS:

 KAISER ALUMINUM
 FABRICATED PRODUCTS
 6573 W. WILLIS ROAD
 CHANDLER, AZ 85226

CERTIFIED TEST REPORT
<http://www.KaiserAluminum.com>

CUSTOMER PO NUMBER:		CUSTOMER PART NUMBER:		PRODUCT DESCRIPTION:										
80-33603		AT11.065/734		Seamless Tube										
KAISER ORDER NUMBER:	LINE ITEM:	SHIP DATE:	KAISER LOT NUMBER:	ALLOY:	TEMPER:									
200438	005	11/27/2007	F00000806	6061	T6									
WEIGHT SHIPPED:	QUANTITY:	BL NUMBER:	QW/MATERIALS:	WEIGHT:	LENGTH:									
331.000 LB	123.000 PCS	200274			12.000 FT									
SHIP TO:	SOLD TO:													
MARMON/KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440 USA	MARMON/KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440 USA													

Actual Physical Properties

REFERENCE	DASH#	SAMPLE#	UTS (KSI)	TTS (KSI)	ELONG%	HARDNESS	CONTACTS	SEND
F00000806	0001	3	46.5	42.6	17.0	N/A	N/A	N/A

Chemical Composition (w%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mo	Cr	Zn	Ti	Pb	B1	Er	Ea	Tot
Maximum	0.60	0.70	0.40	0.15	2.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00	0.00
R22453	.62	.39	.22	.05	.92	.06	.03	.02	.00	.01	.00	.00	.00

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file subject to examination.

Wilfredo A. delaCruz, Sr. Metallurgical Engineer

Wilfredo A. delaCruz

Plant Serial: 00000264

Kaiser Order Number: 200438

Line Item: 005

FEB 06 2008 13:10

AT 1.065 734

Q.C. REVIEWED

PAGE 02

18 2008 15:44 FR MARMON KEYSTONE

6309722464 TO 145841557

18/2008 FROM: MARMON/KEYSTONE

TO:

OR. REF:

INIT.:

SLSPRS:

R OR:
C.P.O.:
C PART:

KAISER
ALUMINUM
FABRICATED PRODUCTS

KAISER ALUMINUM
FABRICATED PRODUCTS
6573 W. WILLIS ROAD
CHANDLER, AZ 85226

Boggs

CERTIFIED TEST REPORT
<http://www.KaiserAluminum.com>

Applicable Requirements:

Description: OD: 1.000"; Wall: 0.065"; Round #
AMS-T-700/6P
ASTM-B210-04 WW-T-700/6P
WE TAKE EXCEPTION TO PARA. 5.2.1. PER AMS 6082N, WAS NOT OILED.
THE FOLLOWING SPECIFICATION HAVE BEEN MADE INACTIVE OR
CANCELLED: MIL-T-7081, WW-T-700F/GEN, WW-T-700/2B, WW-T-700/3F,
WW-T-700/4F, WW-T-700/5B, WW-T-700/6F, WW-T-700/7B.
COMPLIES TO THE REQUIREMENTS OF DIN EN 10204 JAN 2005
COMPLIES TO DIN EN 10204 JAN 2005

Miscellaneous Notes

MANUFACTURED IN USA MELTED IN USA

CERTIFICATION

Kaiser Aluminum Fabricated Products, Inc ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file subject to examination.

Wilfredo A. delaCruz, Sr. Metallurgical Engineer

Wilfredo A. delaCruz

Page 2 of 2

Plant Serial: 00000264

Kaiser Order Number: 200438

Line Item: 005

PAGE.03

FEB 06 2008 13:11

** TOTAL PAGE.03 **

8 7 6 5 4 3 2 1

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D

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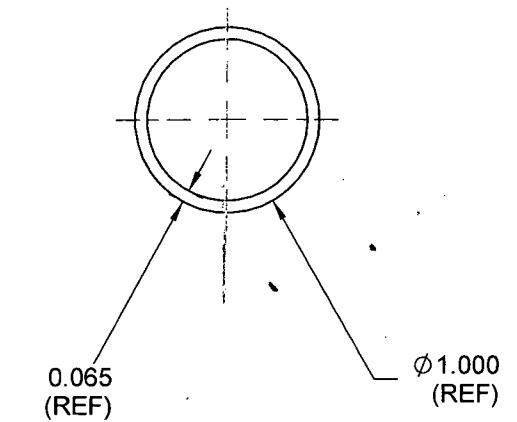
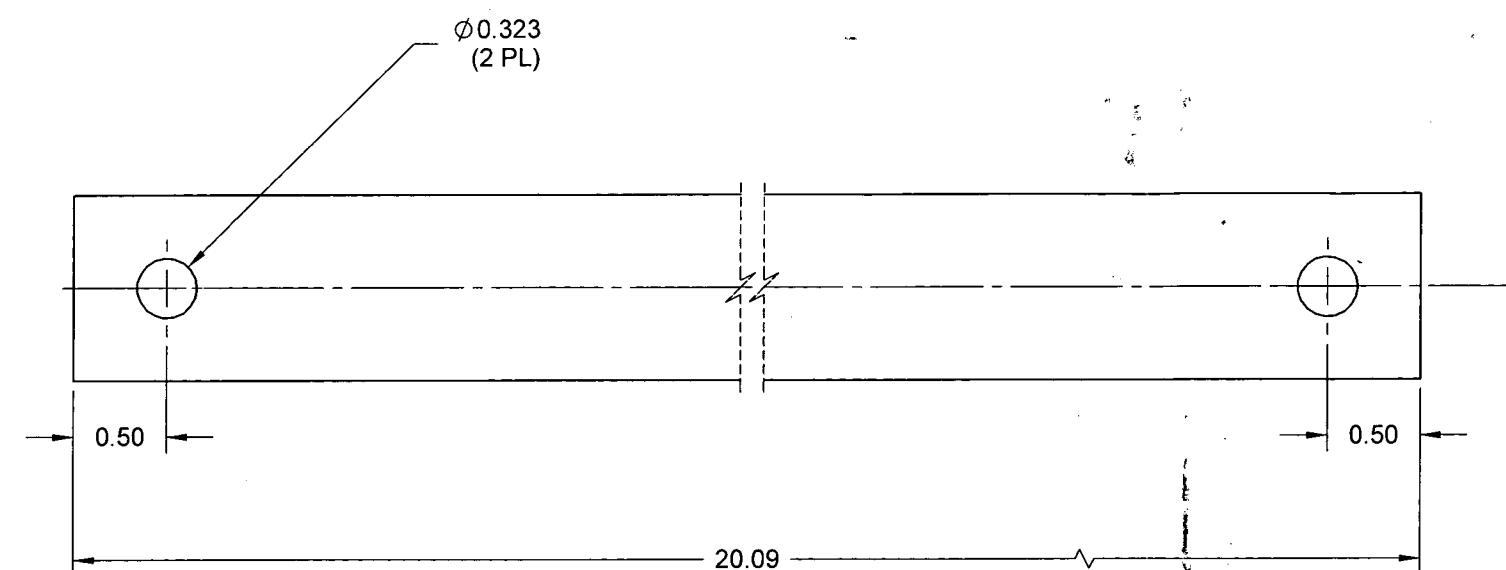
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PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

08.04.23

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	08.03.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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12.04

8.025
12.06
20.085

8.02
12.04
20.42

8.000